

## Abstract

A method of making a pneumatic tire with a breaker and a band, comprises: applying a raw breaker material to a cylindrical drum; spirally winding a plurality of parallel band cords around the raw breaker material on the cylindrical drum so that angles of the windings are not more than 5 degrees with respect to the tire equator; and gradually increasing one of (1) an average density of the band cords in the tire axial direction and (2) an average tension of the band cords in the tire axial direction, from a center portion of the band towards each axial edge of the band during winding the band cords.